

Date: Monday, 1/14/2008 2:37:10 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STOP
Job Number	36749A			
Estimate Number	10731			
P.O. Number			Part Number	D23243
This Issue	1/14/2008	S.O. No. :	Drawing Number	D2324 REV. C
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type : SMALL /MED FAB	Drawing Revision	C
Previous Run	35930A		Material	:
Written By			Due Date	2/20/2008
Checked & Approved By	<u>JF 08/01/15</u>		Qty:	20 Um: Each
Comment	Est: 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"	
		Comment: Qty.: 0.5565 f(s)/Unit Total : 11.1300 f(s) 6061-T6 Bar 0.75" x 0.75" Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8) (M6061T6B0.750x0.750) Batch: M106563 X12PCS M102476 X 9pcs	J.F. 08/02/11 (21)
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (0.75" x 0.75") x 5.75" Long Bar	J.F. 08/02/11 (21)
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1- Machine as per Folio D2324-3 and Dwg D2324 2- Deburr and Tumble to remove sharp edges Identify as D2324-3	J.A./m 08/02/13 (20)
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.A./m 08/02/13 (20)
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	J.F. 08/02/15 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 20/02/2022
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1 	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1		11 08-02-15 (X20)
7.0	QC3 	INSPECT POWDER COAT/CHEMICAL CONVERSION BL 08-02-15 (20)
Comment: INSPECT ALODINE		
8.0	PACKAGING 1 	PACKAGING RESOURCE #1 AS 08/02/19 (20)
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 26		
9.0	QC21 	FINAL INSPECTION/W/O RELEASE AS 08/02/19 (20)
Comment: FINAL INSPECTION/W/O RELEASE		AS 08/02/19 (20)
Job Completion 		AS 2008/2/19 (20) W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

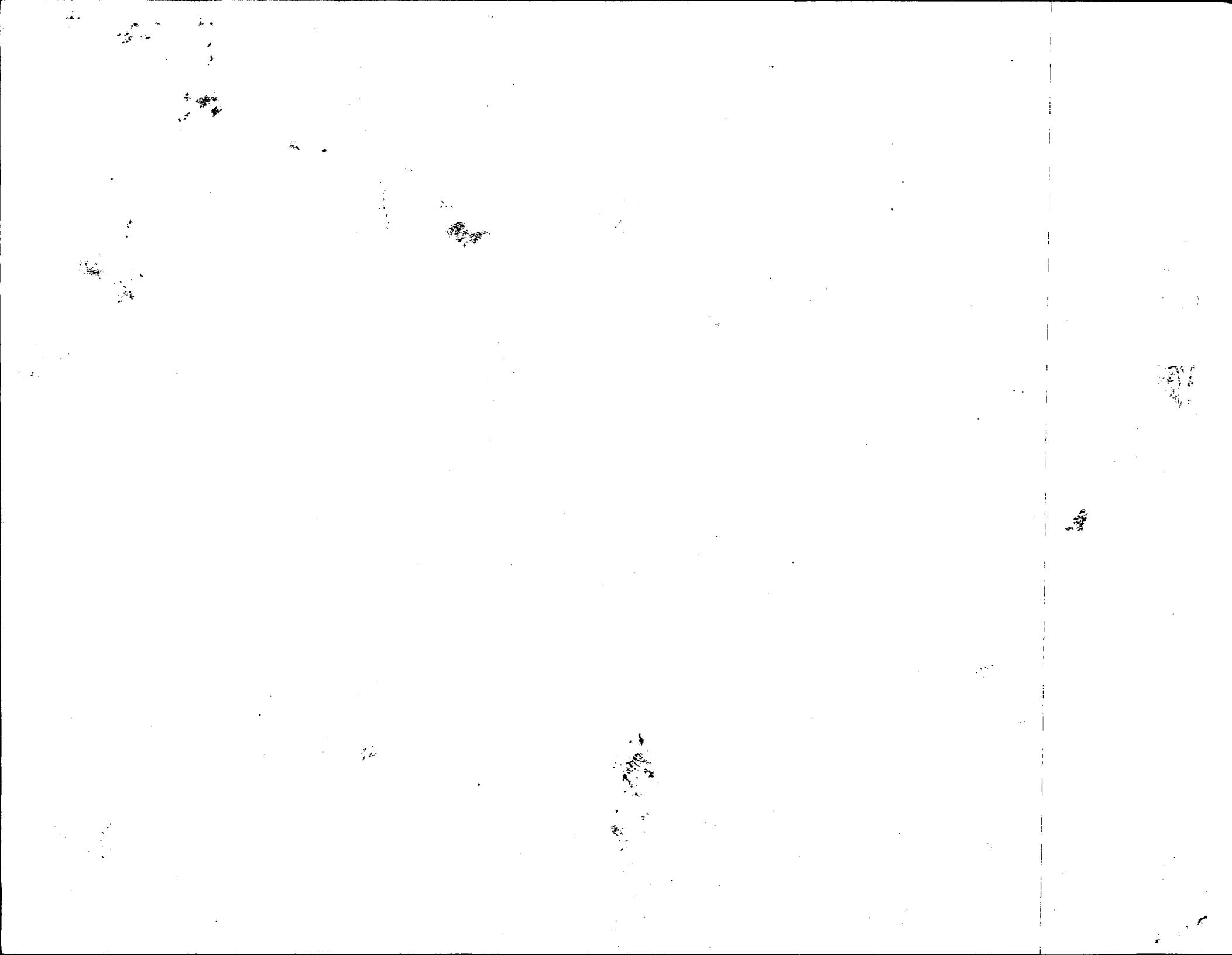
DART AEROSPACE LTD	Work Order:	36749A
Description: Strut	Part Number:	D2324-3
Inspection Dwg: D2324	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>J.A./Am</u>	Audited by:	<u>AG</u>	Prototype Approval:	N/A
Date:	09/02/13	Date:	08/02/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.10	New Issue P/O D2324-1	KJ/JLM	
B	06.03.08	Dwg Rev changed	KJ/JLM	

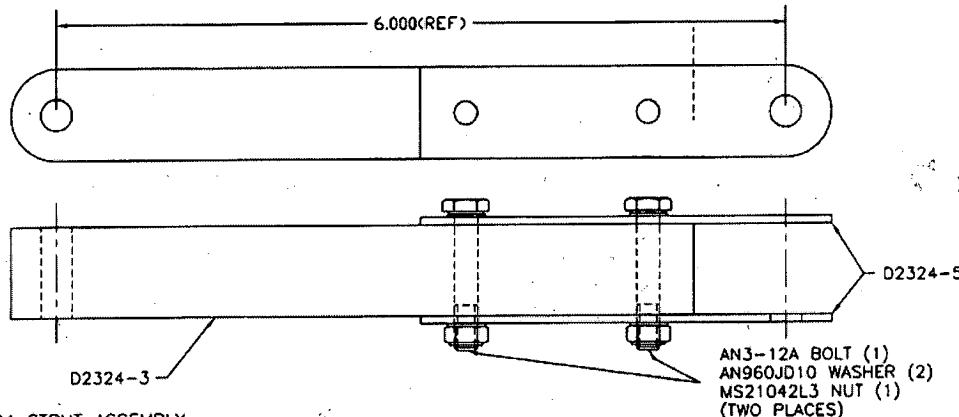


DART

DESIGN B WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD. VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE STRUT	REV. C SHEET 1 OF 1
A	94.11.08	NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

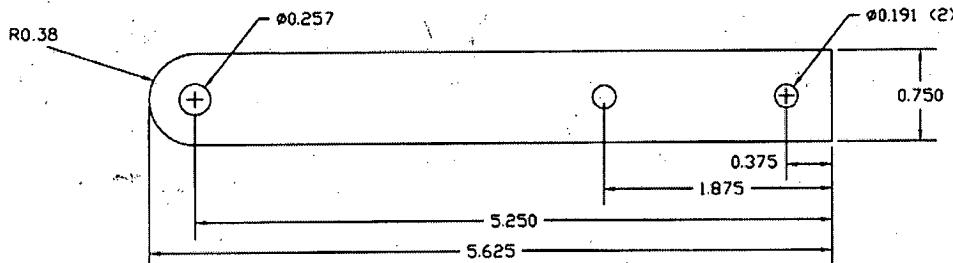
RELEASED

04.12.16 *[initials]*



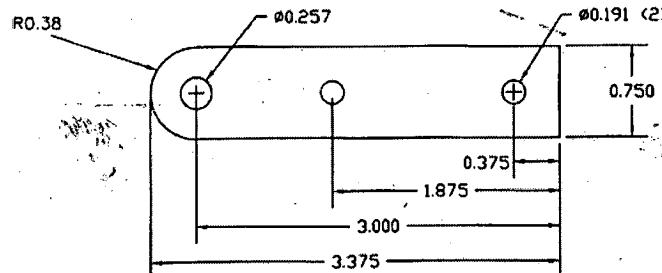
D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
(REF DART SPEC. M6061T6B0.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *36749A*

